

Date: Monday, 3/17/2008 12:00:07 PM
 User: Kim Johnston

Process Sheet

Customer	CU-DAR001 Dart Helicopters Services		Drawing Name	: DECK PLATE,FWD ,350 LITTER KIT		
Job Number	: 38057		Part Number	: D2364		
Estimate Number	: 11104		Drawing Number	: D2364 REV.F		
P.O. Number	:		Project Number	: N/A		
This Issue	: 3/17/2008	S.O. No. :	Drawing Revision	: F		
Prsht Rev.	: NC		Material	:		
First Issue	: / /	Type	SMALL /MED FAB	Due Date	: 3/24/2008	Qty: 8 Um: Each
Previous Run	: 31921					
Written By	:					
Checked & Approved By	:					
Comment	: EST. REV. E 00.06.26 Removed P/O for powder coat EC Est Rev:F Now On Waterjet 06-07-03 JLM					

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M2024T3S063	2024-T3 .063 sheet 7.
Comment: Qty.: 0.6792 sf(s)/Unit Total : 5.4340 sf(s) 2024-T3 .063 Aluminum sheet (M2024T3S063) Batch: 106223 HB 08-3-19		
2.0	WATER JET	FLOW WATER JET
Comment: FLOW WATER JET 1-Cut as per Dwg D2364 Dwg Rev: F HB 8-3-19 Prog Rev: F (10)		
2-Deburr if necessary HB 8-3-19		
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE HB 8-3-19
Comment: INSPECT PARTS AS THEY COME OFF MACHINE		
4.0	QC8	SECOND CHECK (Ph) counter
Comment: SECOND CHECK		
5.0	HAND FINISHING1	HAND FINISHING RESOURCE #1 (10) BL 08-03-25
Comment: HAND FINISHING RESOURCE #1 Chemical Conversion Coat as per QSI 005.4.1		

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
08/03/19	# 4.1	Counter side holes as per Drawing D2364 Rev F - Deburr if all ready added to 08/03/19	MF	08/03/25	10		S 08/03/19	
08/03/19	# 4.2	Inspect QC # 5 if all ready added to 08/03/19	SMB	08/03/25	(X) 10		S 08/03/19	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DECK PLATE,FWD ,350 LITTER KIT

Job Number: 38057

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Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 POWDER COATING



POWDER COATING

M100700



10X

Comment: POWDER COATING

Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3

m.f.

08/03/26

7.0 QC3



INSPECT POWDER COAT/CHEMICAL CONVERSION

gsl



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

08-03-26 X 10

8.0 PACKAGING 1



PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 57186

57186

08/03/27 10

10

9.0 QC21



FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/03/27

10

Job Completion



mr

08-03-27

W

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	38057
Description:	Litter Deck Plate Kit (350)	Part Number:	D2364
Inspection Dwg:	D2364	Rev:	F

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FIRST ARTICLE INSPECTION CHECKLIST

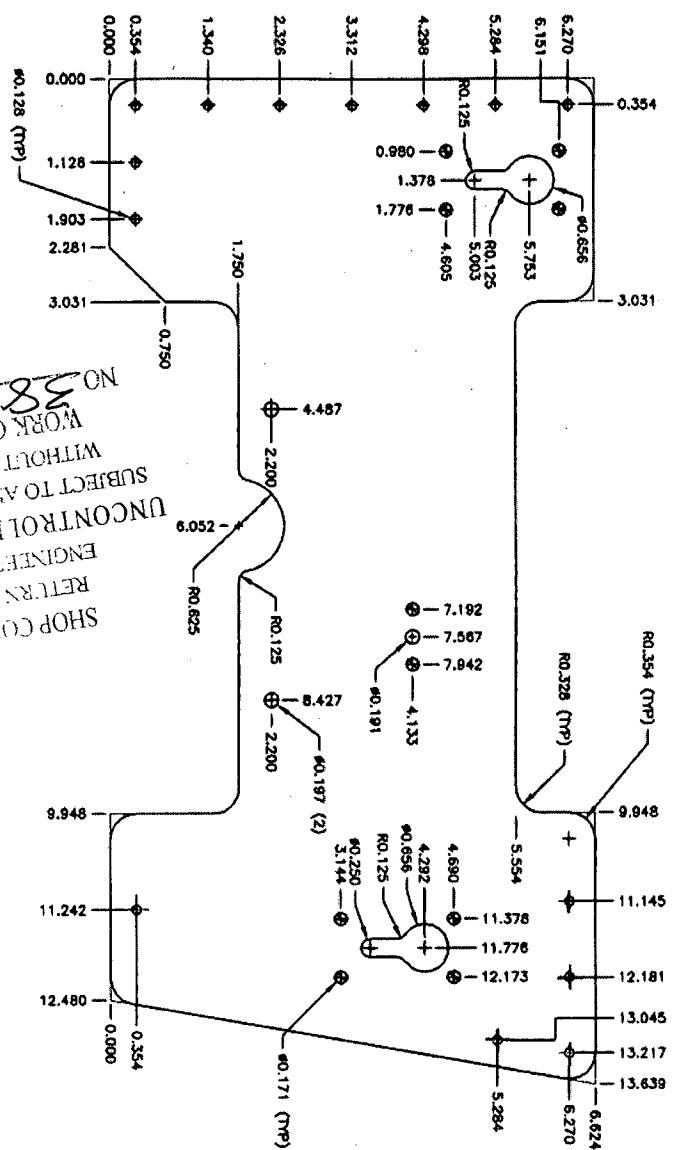
First Article Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
6.624	+/-0.010	6.628	*			
Ø0.171	+0.005/-0.000	.175	*			
0.354	+/-0.010	.354	*			
11.242	+/-0.010	11.247	*			
3.031	+/-0.010	3.025	*			
1.903	+/-0.010	1.903	*			
1.128	+/-0.010	1.128	*			
0.354	+/-0.010	.351	*			
1.340	+/-0.005	1.339	*			
2.326	+/-0.010	2.326	*			
3.312	+/-0.010	3.312	*			
4.298	+/-0.010	4.298	*			
5.284	+/-0.010	5.285	*			
6.151	+/-0.010	6.152	*			
6.270	+/-0.010	6.270	*			
0.354	+/-0.010	.354	*			
3.031	+/-0.010	3.030	*			
Ø0.656	+0.005/-0.000	.660	*			
5.003	+/-0.010	5.003	*			
4.605	+/-0.010	4.606	*			
1.776	+/-0.010	1.778	*			
0.980	+/-0.010	.981	*			
4.487	+/-0.010	4.488	*			
7.192	+/-0.010	7.194	*			
7.597	+/-0.010	7.597	*			
7.942	+/-0.010	7.943	*			
Ø0.191	+0.005/-0.000	.195	*			
Ø0.197	+0.005/-0.000	.201	*			
11.145	+/-0.010	11.145	*			
12.181	+/-0.010	12.181	*			
11.378	+/-0.010	11.378	*			
11.776	+/-0.010	11.776	*			
12.173	+/-0.010	12.173	*			
4.690	+/-0.010	4.691	*			
Ø0.250	+0.005/-0.000	.255	*			
3.141	+/-0.010	3.143	*			
Ø0.171	+0.005/-0.000	.176	*			

Measured by:	BB	Audited by:		Prototype Approval:	N/A
Date:	8-3-19	Date:	08/03/19	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.06.25	New Issue	KJ/JLM	SM

COUNTER SINK HOLES:
◆ C'SINK Ø0.225 x 100° (UPDATED FROM 9 TO 14 HOLES BY DS 9.03.01 TO CORRECT CAD ERROR)
◆ C'SINK Ø0.308 x 100°



MATERIAL: 2024-T3 (QQ-A-250/5) 0.063-0.071 THICK
FINISH: POWDER COAT BLACK CRINKLE (4.3.5.3) PER DART QSI 005 4.3
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

A	95.01.14	NEW ISSUE	
98.06.19	LITTER DECK PLATE, 350 SCALE	TMLE	25
95.02.09	MOVED KEYWAY		
95.03.06	0.191 WAS 0.197		
E	95.10.06	GEOMETRY CHANGES	
F	98.06.19	0.063-0.071 THICK WAS 0.071 (TSR A371)	

98/06/22 KG

DART